Work Order April-30-13 2:39:3		069	· .	*10	1069*						Page 1
Item ID: D4 Revision ID:	4095-047	,		Accept	*N90	೧೧4 ೧	100)* s	Setup Start	IVI	S1*
Item Name: We	earpad Assem	bly-						•	Stop	*NS	S 2*
Start Date: 4/3 Required Date: 4/3		Start Qty: 6.00 Req'd Qty: 6.00	*6 *0		Cust Ite Custome	*					
Reference:		rug a Qiji oloo	*6	••	Custom	<u>.</u>					
Approvals: P	Process Plan	ML5	Date: /3-0	5-e(Tooling:		Date:		R	Run Start	1/1	२ 1*
Q)C:		Date:	SPC (Y/N) :	· · · · · · · · · · · · · · · · · · ·	Date:			Stop	*NF	₹2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool II	D Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr	······································				-1		* *************************************		
D4095	В										
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Waterjet FLOW CNC Waterjet		Memo	er Dwg (D4095-7)	0.00		-				,	/ /
304.063		Dwg Rev:_ Prog Rev:_ 2-Deburr i	<u>B</u>								•
110	(QC2- Inspect parts off	 machine FAI/FAIB	0.00			ŧ				
110								6		. Ae	13.05
QC	*	Memo		0.00			•	,		/	
Quality Control	~										
120	. (QC8- Inspect parts - sec	cond check	0.00	7			Ĵ			
120				•				6			
QC		Memo		0.00	524						·
Quality Control			•		•						

NCR: Y	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:												
						DISPOSITION				AGAINST DI	EPARTMENT,		•
Work Orde	ŕ:				· · · · · · · · · · · · · · · · · · ·	DISPOSITION	_ 1						
						Rework	↓ Ⅰ		Skid-tube	Crosstube	-	Water Jet	Engineering
Part N	o					Scrap	↓ Ⅰ		Machining	Small Fab	→	d. Eng. Coor.	Quality
						Use-as-is	1 1		noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo					Work Order Update	╛┃		Large Fab	Composite		Supplier] []
Root					Descri	ption of work order update	lr	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Descr	iption	Date	Verification	QC Inspector
oc/Data													
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	В	ending				Bend	Ш	Grain		<u> </u>	Ovalized		Pressure/Forced
	c	entre No	t Concer	ntric to (o/s	BOM/Route	Ш	Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
٠.	C	racks				Broken/Damaged		Inspecti	on Incomplete	<u> </u>	Part Incorred	t	Weld
	Ci	rushed/C	rimped		,	Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
[uffs				Contamination		Mainte	enance		Part Moved		
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	ir	spection	Strip in	Tube		Cut Too Short		Misreac	i		Power Loss/	Surge	Other
	R	ipples in	Bend			Drill Holes		Offset					
	T	orque W	aves in E	xtrusio	n, [Drawing		Out of (Calibration				
1	TI	urning Se	equence			Finish		Out of S	Sequence	•			
	\square _v	Vave/Twi	st in Tub	oe		Folio		Outside	Dimensions				

DQA:

Date:

Work Orde April-30-13 2:3:		1069		*101	IN69*				Page 2	
Revision ID:	D4095-047 Wearpad Asse	mbly		Accept	*N900	<u>040100</u>)* s	Setup Start	*NS1* *NS2*	
Start Date: Required Date: Reference:	4/30/13 4/30/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:				
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:	F	Run Start Stop	"INK I"	
Sequence ID/ Work Center II 130 *130* Brake NC Brake NC)	Operation Description Form as per dwg NC BRAKE Memo		Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp	1/05/2
140 - *140* QC Quality Control		QC5- Inspect part compl	leteness to step on W/O	0.00 S) 2 Xl 0000	27		6		, .	
150 *150* Large Fab		Weld per dwg A/R Har Large Fab	dcoat S.S. Batch: M) 1	0.00			6		13-6	15]] Non

Memo

Large Fab

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UF	PDATE		04.61			
						T					_	QA Closed:	Da	ate:	
Work Ord	or.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
WOIK OIG	<u>.</u> .					Rework	1		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part !	No.					Scrap	1	3	Machining	Small Fab	┨	Pro	d. Eng. Coor.	-	Quality
	•		<u></u>			Use-as-is	1	•	noforming	Finishing	٦		e/Packaging		Other
NCR I	No.					Work Order Update			Large Fab	Composite	٦	-	Supplier	_	
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Root					Descri	ption of work order update		Initial	A	ction		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	cription	┙	Date	Verification	n	QC Inspector
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Other			ļ.									İ			
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		Bending				Bend		Grain		_	╛	Ovalized		L	Pressure/Forced
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		Cracks				Broken/Damaged		Inspecti	on Incomplete		╛	Part Incorrec	t	L	Weld
		Crushed/	Crimped		t.	Burrs		Instruct	ions Incomplete,	/Unclear	╛	Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		\rfloor	Part Moved			
		Heat Tre	at			Countersink		Mislabe	led			Positioned W	/rong		_
		Inspection	n Strip in	Tube		Cut Too Short	Misread Power Loss/Surge								Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 101069 April-30-13 2:39:31 PM				*101069*								Page 3		
Item ID: Revision ID: Item Name:	D4095-047			Accept		N900	040	100)* s	etup S	Start Stop	*N: *N:	S1* S2*	
Start Date: Required Date Reference:	4/30/13 : 4/30/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			Cust Item I Customer:	D:							
Approvals:		lan:		Tooling SPC (Y/			ate:		R		Start Stop	*NI *NI	R1* R2*	
Sequence ID/ Work Center I 160 *160* QC Quality Control	D	Operation Description QC10- Inspect visual pe	r QSI004- ground welds	Set U Run 0.00 0.00	19/ Hours 209 13-S 2	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp	
170 *170* QC Quality Control		QC5- Inspect part comp Memo	leteness to step on W/O	0.00	27 27 13 S O	8			6					
*180 *180* HandFinish Hand Finishing		DWG	FIRE TOP (CONCAVE) SI KGUARD BATCH: _ 2		TH ROCKGUARE	O AS PER			6_		5_	Ø	Af 13-5-32	

NCR:	Yes	1	No
IACIV.	162	,	110

DQA:

Date:

NCR: Y	·											
										QA Closed:	Date:	:
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	-				Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	0				Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is] '	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	o				Work Order Update			Large Fab	Composite]	Supplier] []
Root		T		Descri	Iption of work order update		Initial	Acti	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
oc/Data						T						
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	Bending			-	Bend	\vdash	Grain		ļ	Ovalized		Pressure/Forced
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ŀ	Cracks	(C-:		_	Broken/Damaged	-	4	ion Incomplete		Part Incorred		Weld Wrong Stock Pulled
-	⊣ '	/Crimped		`	Burrs	\vdash	Mainte	ions Incomplete/U	inclear	Part Lost/Mi Part Moved	ssing	I wrong Stock Pulled
-	Cuffs			<u> </u>	Countarion	\vdash	Mislabe			Positioned W	Irong	
, }	Heat Tre	at on Strip in	Tubo	-	Countersink Cut Too Short	-	Misread		-	Power Loss/		Other
}	Ripples i	-	Tube	-	Drill Holes	\vdash	Offset	ı	L	Trower rossy.	Duige	Jourer
}		n Bend Naves in I	Evtrucio	,	Drawing	-	4	Calibration				
}		Sequence		' 	Finish	-	4	Sequence	٠			
l l	Trutting.	ocquence		1	le music	1	Tour or -	requeries				

Outside Dimensions

Wave/Twist in Tube

Folio

Work Ord April-30-13 2:)1069			Page 4						
Item ID: Revision ID: Item Name:	D4095-047 Wearpad Ass		·	Accept	*N900	0401	^^*	Set	tup Start Stop	1 1	S1* S2*
Start Date: Required Date Reference:	4/30/13 : 4/30/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:			S4a v4		
Approvals:	Process Plan:		Date:	Tooling: SPC (Y/N):	D:		Ru	in Start Stop		R1* R2*	
Sequence ID/ Work Center I 190 *1 90* QC Quality Control	I D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00 SV 0.00 JS. S	Tool ID	Tool# Pla	an Acc ode Qty		Reject Qty	Reject Number	Insp. Stamp
200 *200* Packaging		Identify as per dwg & Sto Memo	ock Location: FP	0.00		4	7 6,	X	M. Dr	<u>13 -</u> 0	0 <u>5-3/</u>

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

210

210

Quality Control

13/6/4 D MF (353)

		DQA:	Date:	
ICP: Ves / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

									QA Closed:	Dat	e:
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	Th	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
Root				Descr	iption of work order update	Initia	1 /	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng De	scription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training											
Unapproved	.	<u> </u>	<u> </u>	L	F	AULT CA	L TEGORY			<u> </u>	
Landir	ng Gear	· · · · · ·			General	HOET CA	TEGOIL!				
	Landing Gear General Bending Bend Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged Crushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Drawing Turning Sequence Finish				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Insp Instr Mai Misl Misr Offs	lware ection Incomplete uctions Incomplet ntenance abeled ead		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Sequence Wist in Tu			Folio		or sequence side Dimensions				
		WIST IN 111	ne		1FOIIO	1 1031179	age Dimensions				

Page 1

Work Order ID:

101069

Parent Item:

D4095-047

Parent Item Name:

Wearpad Assembly

Start Date: 4/30/13

Required Date: 4/30/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP rev.A 11.11.07 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	268.4214		0.882	, // ,	2 05.	21
304/316 Sheet .063											14/1	3.05	<u>عرا</u>
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		268.4213688			<u>123</u>	599			

0.1713688

140.8

98.45

29

122245

123136

124428

124572

										DQA:			
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et.					DISPOSITION			A	GAINST DE	PARTMENT		·	
Work Orde	r:					_					_	, , ,	
					Rework	-		⊢ —	osstube		Water Jet	Engineering	
Part N	lo				Scrap	-		~ ⊢	mall Fab	4	d. Eng. Coor.	Quality	
1100 1					Use-as-is	┦╏╜		~ —	inishing	Rec/Stoi	re/Packaging	Other	
NCR N	10				Work Order Update	┚╽		Large Fab Co	mposite	J	Supplier	J ∐	
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Operator	_												
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Setup							1						
Other													
Process													
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Bend							ain		<u> </u>	Ovalized		Pressure/Forced	
Centre Not Concentric to O/S BOM/Route					\vdash	rdwai		<u> </u>	Over/Under	<u> </u>	Temperature/Cure		
Cracks Broken/Damaged					\vdash	•	on Incomplete		Part Incorred	<u> </u>	Weld		
Crushed/Crimped Burrs					├ ──		ons Incomplete/Unclea	ar L	Part Lost/Mi	ssing	Wrong Stock Pulled		
Cuffs Contamination					╡	\vdash		nance	<u> </u>	Part Moved			
	Heat Trea			<u> </u>	Countersink	\vdash	slabel	•	<u> </u>	Positioned V		٦.	
	Inspectio	n Strip in	Tube		Cut Too Short	Mi	sread			Power Loss/:	Surge	Other	

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	101069	
Description: Wearpad	Part Number:	D4095-7	
Inspection Dwg: D4095 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing _ Actual Method of								
Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
+/-0.010	0.200			VERN	JKM-01			
+/-0.010	1			V				
+/-0.010				V				
+/-0.010		/		1/				
+/-0.010		/			,			
+/-0.030		/		V				
+/-0.030				V				
+/-0.010		/		V				
				14,				
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*		oAs						
	+/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.030 +/-0.030	Tolerance Dimension +/-0.010 +/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.010 -/-0.030 -/-0.030 -/-0.030 -/-0.030 -/-0.030 -/-0.030 -/-0.030 -/-0.030	Tolerance +/-0.010 +/-0.010	Tolerance Dimension Accept Reject	Tolerance Dimension Accept Reject Inspection			

Measured by:	Ae INA	Audited by:	27	Preliminary	Approval:	
Date:	13,05,24	Date:	13504		Date:	
· · · - · - · - · · ·	1					

Rev	Date	Change	`	Revised	μλ	Approved
Α	11.11.08	New Issue	P/O D4095-047	KJ (JV	M
4					7	



